

Work Order ID 51944

Thursday, September 10, 2009 8:24:55 AM



Page 1

Item ID: D3065-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: PL Date: 09-9-10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100
Waterjet
FLOW CNC Waterjet
2024 .040
Memo
1-Cut as per Dwg D ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

0.00

MAT NOT PULLED

B 9-9-15

(44)

110
QC
Quality Control
QC2- Inspect parts off machine FAI/FAIB
Memo

0.00

0.00

B 9-9-15

120
QC
Quality Control
QC8- Inspect parts - second check
Memo

0.00

0.00

=> Sorlos

count
(44)

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Stop



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Start Date: 9/11/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00	N/A						
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140 	NC BRAKE	0.00	SB 09/09/17			44	0		
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150 	QC5- Inspect part completeness to step on W/O	0.00	=> 502/02/17			counted x44	/		
QC	Memo	0.00							
Quality Control									

Work Order ID 51944

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Item ID: D3065-3	Accept		Setup	Start	
Revision ID: B				Stop	
Item Name: Step Spacer					
Start Date: 9/11/2009	Start Qty: 40.00		Cust Item ID:		
Required Date: 9/25/2009	Req'd Qty: 40.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	MD	09/09/21		(X44)			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	M.L	09/09/21		(44X)			
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>SPLUR</u> Memo	0.00 0.00							(44)

Work Order ID 51944

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Page 4

Item ID: D3065-3

Accept

Revision ID: B

Item Name: Step Spacer

Start Date: 9/11/2009 Start Qty: 40.00

Required Date: 9/25/2009 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21 JF
MF 09-09-21

Picklist Print

Thursday, September 10, 2009 8:25:02 AM

Page 1

Work Order ID: 51944



Parent Item: D3065-3RevB



Parent Item Name: Step Spacer

Start Date: 9/11/2009

Required Date: 9/25/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	230.3565	9.1705	10.0925		
2024-T3 .040 sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

230.3564789

110337

6.4

111786

39.0665789

112291

91.9258

112331

92.9641

112331 X 44

DART AEROSPACE LTD		Work Order: 57944
Description: Step Spacer		Part Number: D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.260	X			
3.260	+/-0.010	3.261	X			
5.260	+/-0.010	5.260	X			
6.520	+/-0.010	6.522	X			
2.093	+/-0.010	2.090	X			
3.936	+/-0.010	3.934	X			
4.186	+/-0.010	4.184	X			
Ø0.128	+0.005/-0.000	.132	X			
Ø1.250	+0.005/-0.000	1.253	X			
Pitch 1.204	+/-0.005	1.203	X			
0.040	+/-0.010	.041	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-15	Date: 07/09/15	Date:	N/A

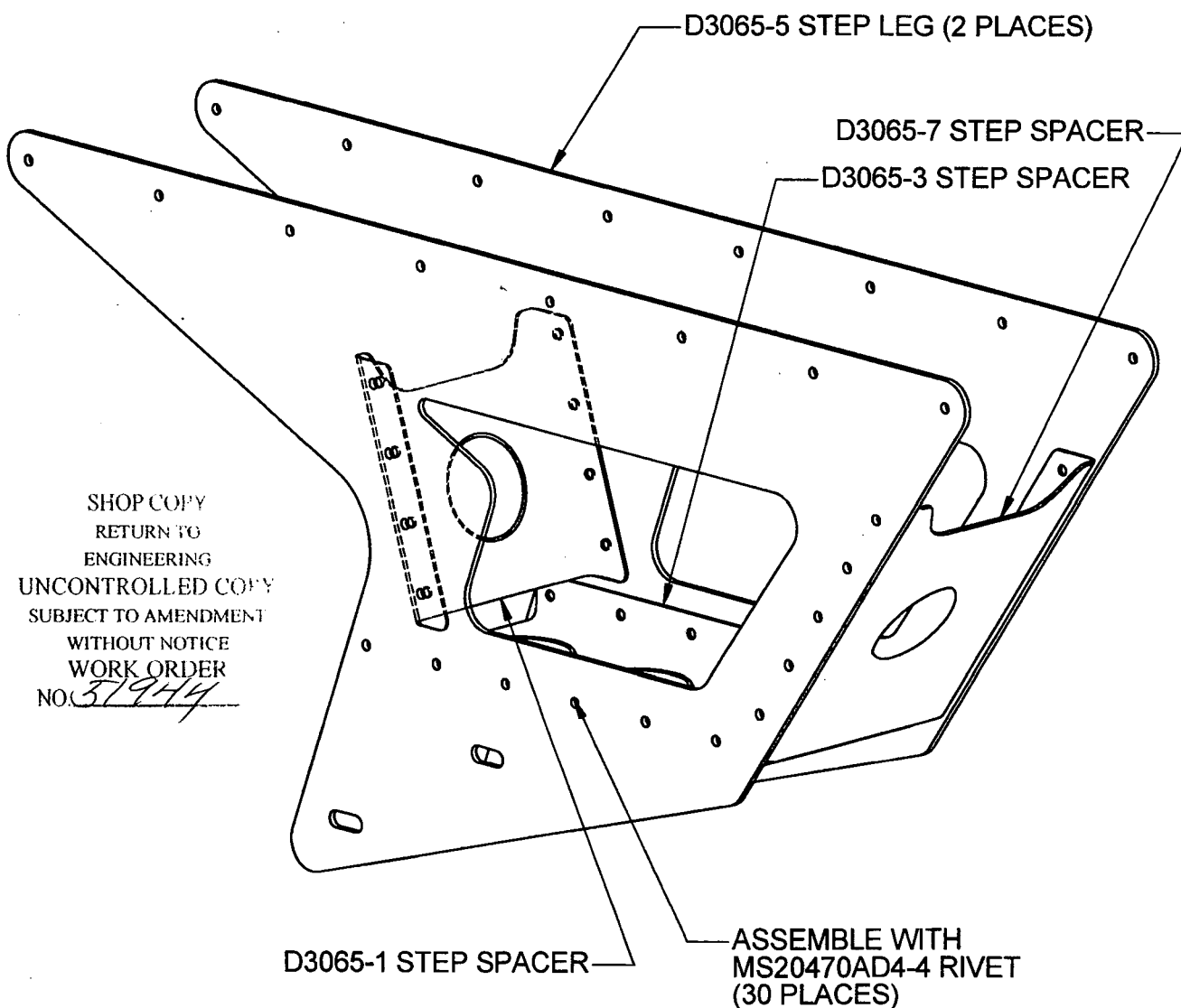
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	CE



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37944

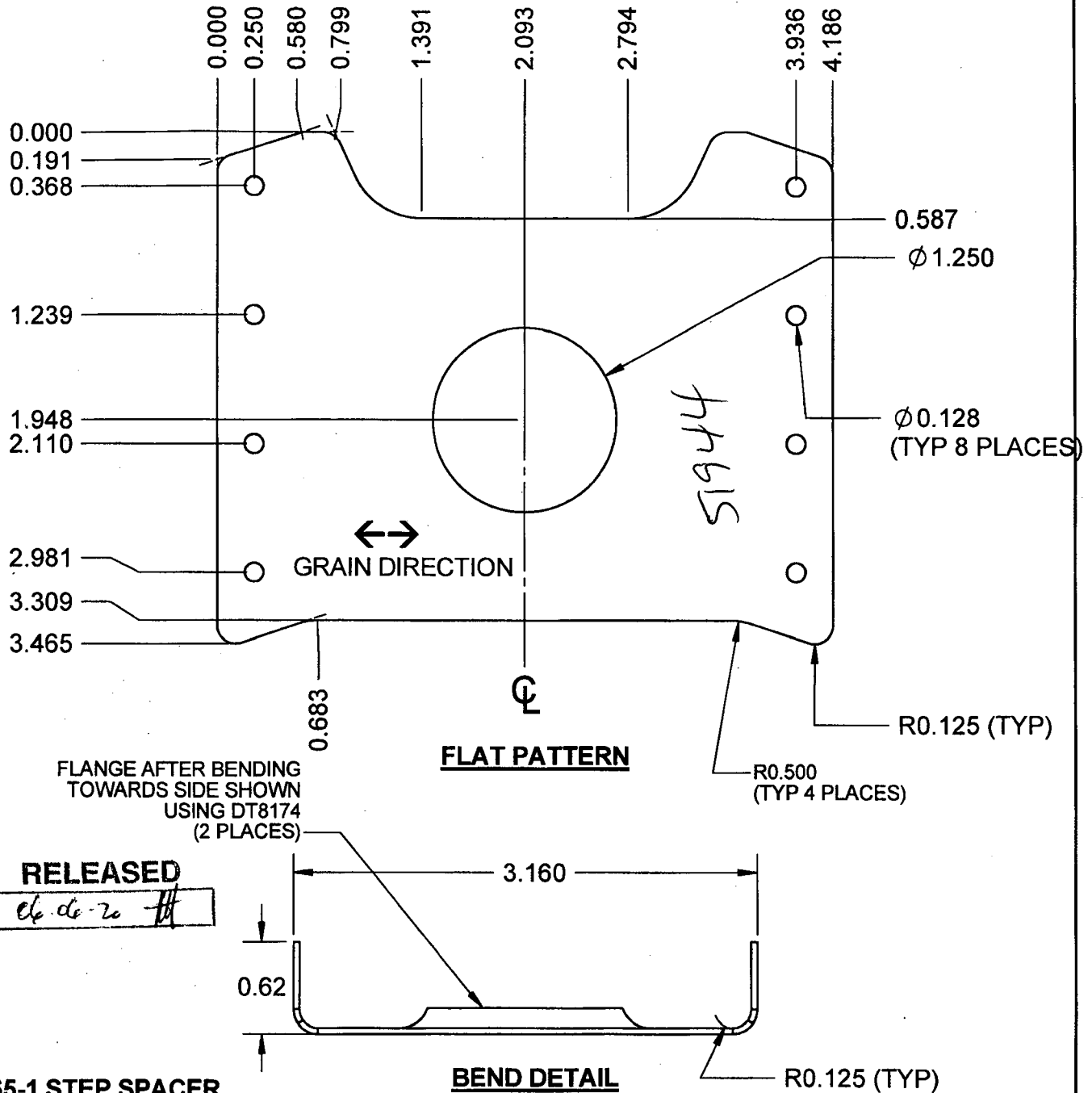
D3065-041 STEP LEG ASSEMBLY

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-1 STEP SPACER

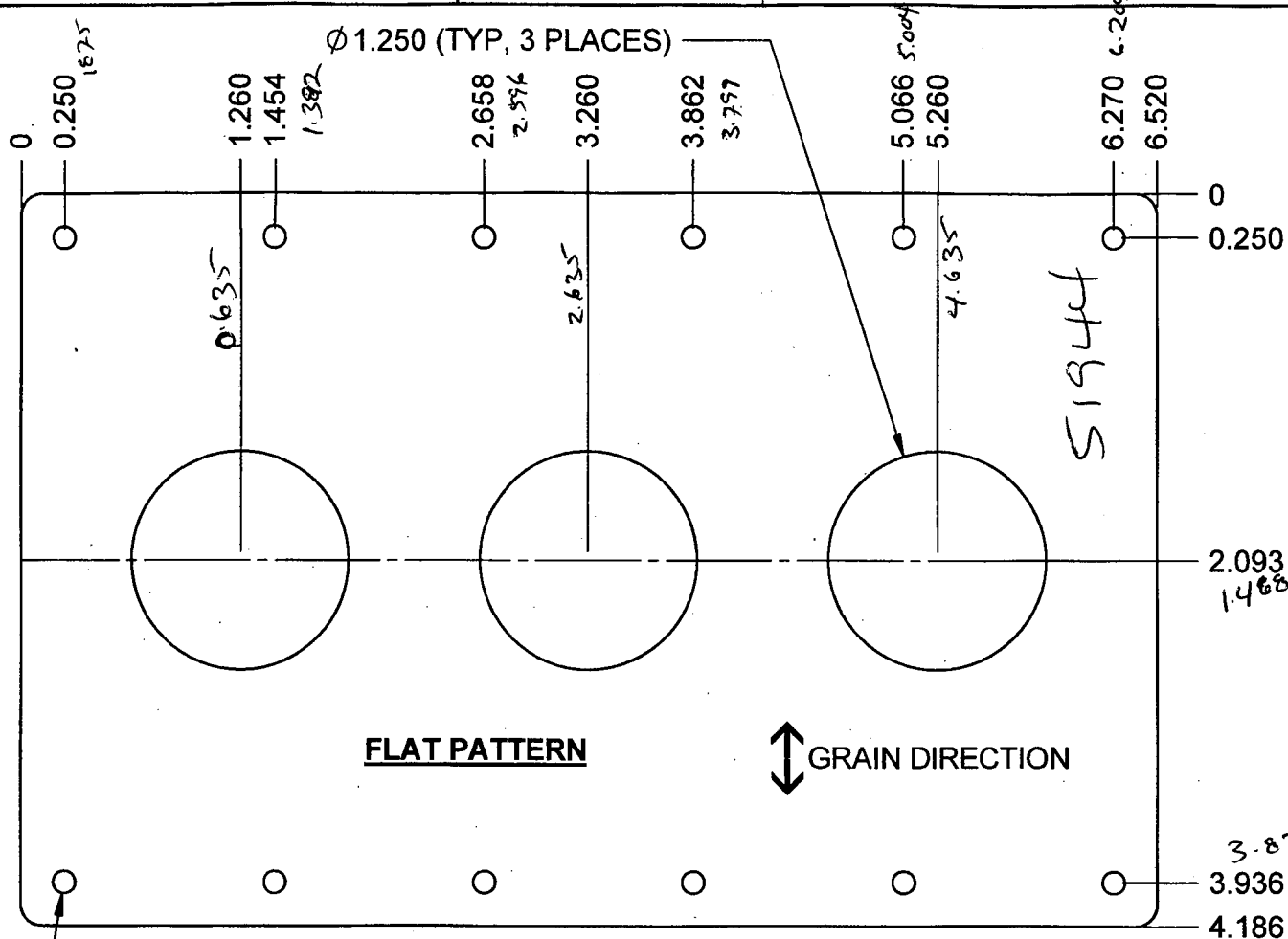
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

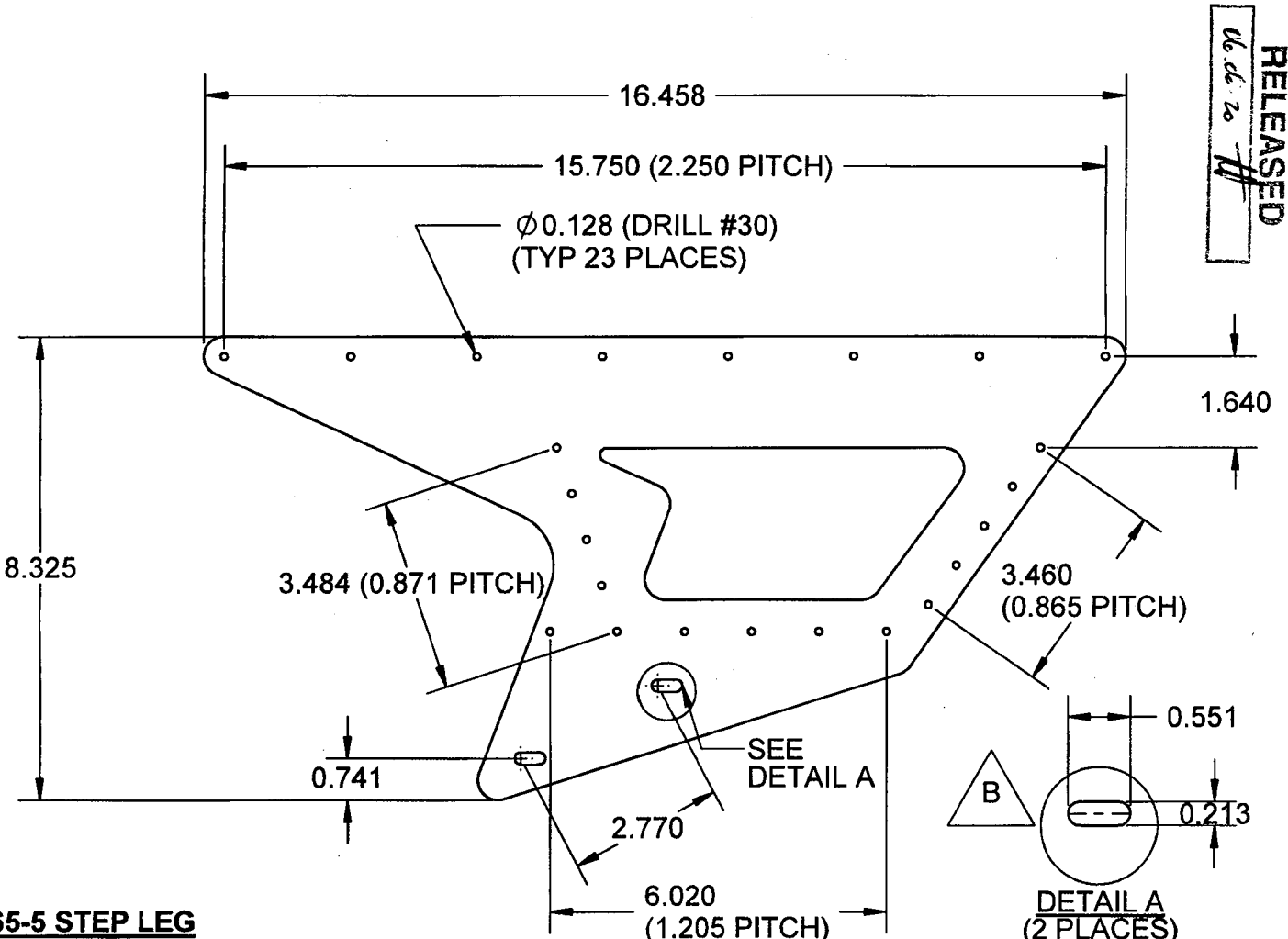
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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CHECKED	APPROVED	DRAWING NO.	REV. B
PH	AK	D3065	SHEET 4 OF 5
DATE	TITLE		SCALE
06.05.23	STEP LEG ASSEMBLY		1:3

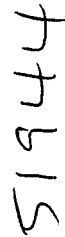
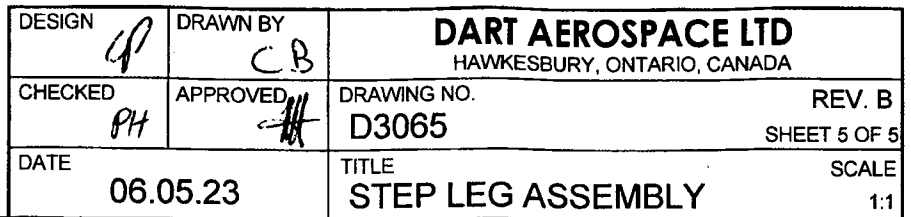


D3065-5 STEP LEG

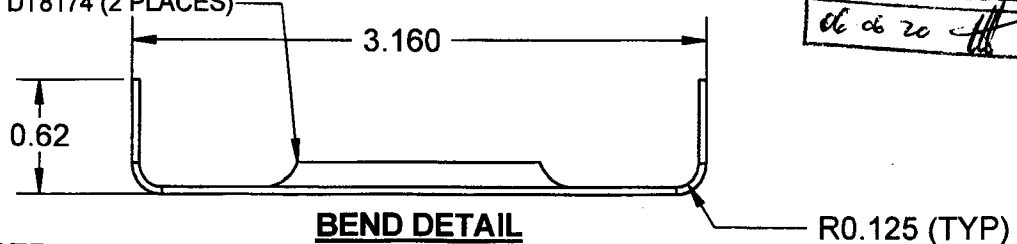
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080) 51944
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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RELEASED



1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
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